

F. Richter

# Work Order ID 73821



Friday, September 16, 2011 10:50:06 AM

Page 1

Item ID: D3413-1

Accept



Setup Start



Revision ID:

Item Name: Ring

Stop



Start Date: 9/16/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 80.00



Customer:

Reference:

V

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3413	Rev A

100



FLOW WATER JET

Waterjet

Memo

0.00

111-9-22

FLOW CNC Waterjet

354 .250X4.00

1-Cut as per Dwg D3413  
Dwg Rev: A  
Prog Rev: A  
2-Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

111-9-22

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

S 110/04

Count to

(41)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 73821**

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Item Name: Ring

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Start Date: 9/16/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130

Operation  
Description

Small Fab

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Small Fab



Memo

0.00

Small Fab

1- Deburr and drill hole if required as per dwg D3413 &amp; QSI018 4.1.

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S. u. l. o. l. o. y

QC

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME:

8:40

0.00

LIOVEN TEMPERATURE:

□ FINISH TIME:

9:10

41XØ ml 11/10/06

WU 8439

4000=

9:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**Work Order ID 73821**

Friday, September 16, 2011 10:50:06 AM



Page 3

Item ID: D3413-1

Accept



Setup Start



Revision ID:

Item Name: Ring

Stop



Start Date: 9/16/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*41* *BL 11-10-6*

170

Identify as per dwg & Stock Location *ST 308* 0.00

Packaging

Memo

0.00

Packaging

*(41)* *SP 11-10-6*

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

*11-10-6*

*MC*

*11-10-6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

Friday, September 16, 2011 10:50:03 AM

Work Order ID: 73821



Parent Item: D3413-1



Parent Item Name: Ring

Start Date: 9/16/2011

Required Date: 10/14/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP Rev:A□05.09.13□New issue□KJ/JLM  
IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000  304 BAR .250 x 4.00		Purchased  	No			100	f	13.0000	0.25	21.05263   <u>BH - 9-22</u>			

Location	Loc Qty	Loc Code
MAT009	13	
118182	13	<u>18182</u>

(41)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	J3821
Description: Ring	Part Number:	D3413-1
Inspection Dwg: D3413	Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article X Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11-9-22	Date:	11/10/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	E

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

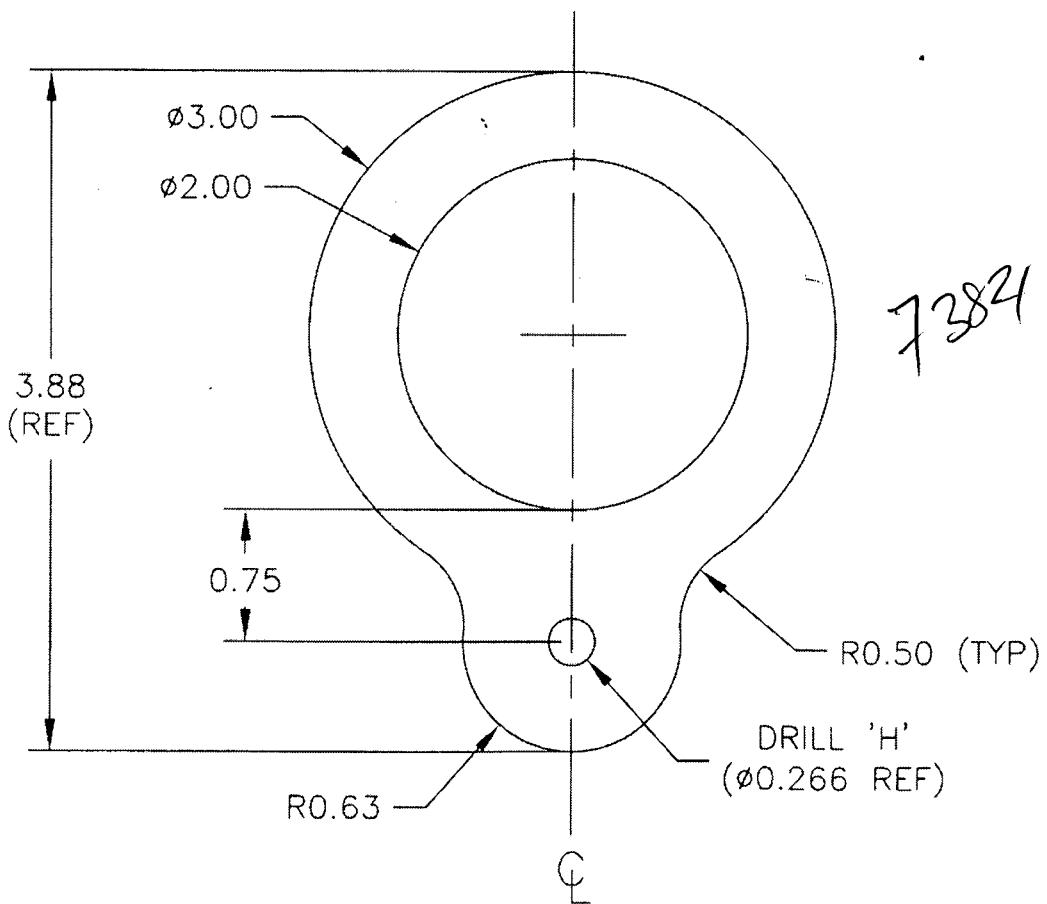
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3413
DATE 05.03.16		REV. A SHEET 1 OF 1
A	05.03.16	TITLE RING
		SCALE 1:1
		NEW ISSUE

**D3413-1 RING**

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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